

Work Order ID 58357

Tuesday, May 04, 2010 10:13:23 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 5/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-5-4 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								
100		0.00							



Memo

0.00

1- Cut tube 50" DSAD 10-05-04
 2- Bend tube with manuel pipe bender as per DT9567 ID
 *** Make line at 9.00" and use jig for other line***
 3- Trim access tube material to finish size as per dwg D3916 PD
 4- Drill and chamfer holes as per dwg D3916-1 using DT9605 PD
 5- weld bushing as per dwg D3916
 6- grind welds flush

(8)

(4) PD 10.05.06
 (5) PD 10/05/06

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

S wls/076

(5)

Quality Control

10/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Sulustog



130



Packaging

Packaging

Identify as per dwg & Stock Location: fasket

0.00

8 PD 10.05.07

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/07 JF

MF
10-5-7

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Picklist Print

Tuesday May 04, 2010 10:13:23 AM

Page 1

Work Order ID: 58357



Parent Item: D3916-041



Parent Item Name: Rib Assembly

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 5/4/2010

Required Date: 5/13/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	112.0000		7		



Bushing

SAD 10-05-04

M304TS0.750W.049



304 SQ Tube .75x.75x.049W

Purchased

No

Location

WA	112	
54072	9	
57852	3	
58159	100	

Loc Qty

Loc Code

- 56

SAD 10-05-04

Location

MAT	200	
113763	0	
114323	200	
MAT017	390.8285368	
113763	24.25	
114270	200	
114298	166.578537	

Loc Qty

Loc Code

4.166 X 9 = 37.494
~~37.494~~

39.3687 with
5% waste

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

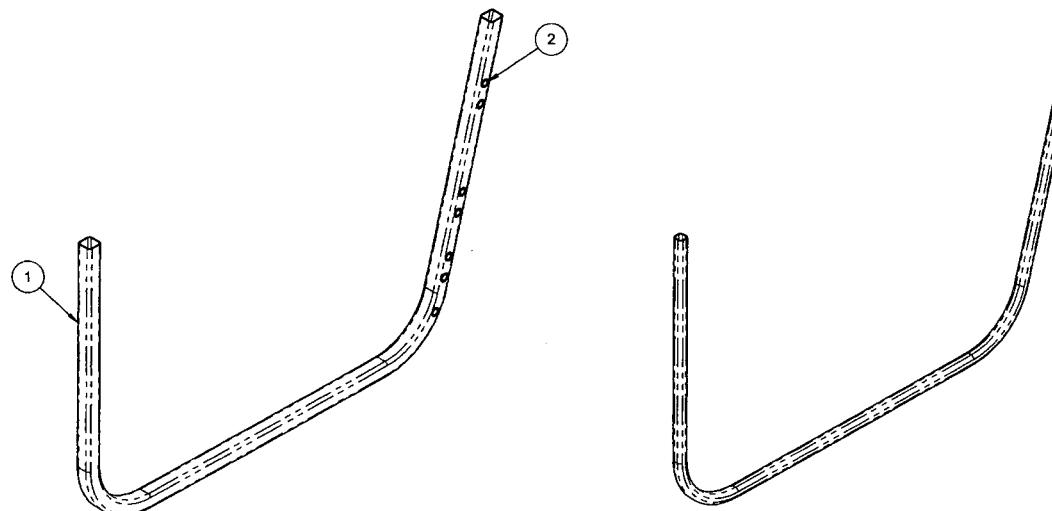
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

#58351



D3916-041 RIB ASSY

D3916-5 LIGHT RIB

RELEASED
2010-03-12
JMP

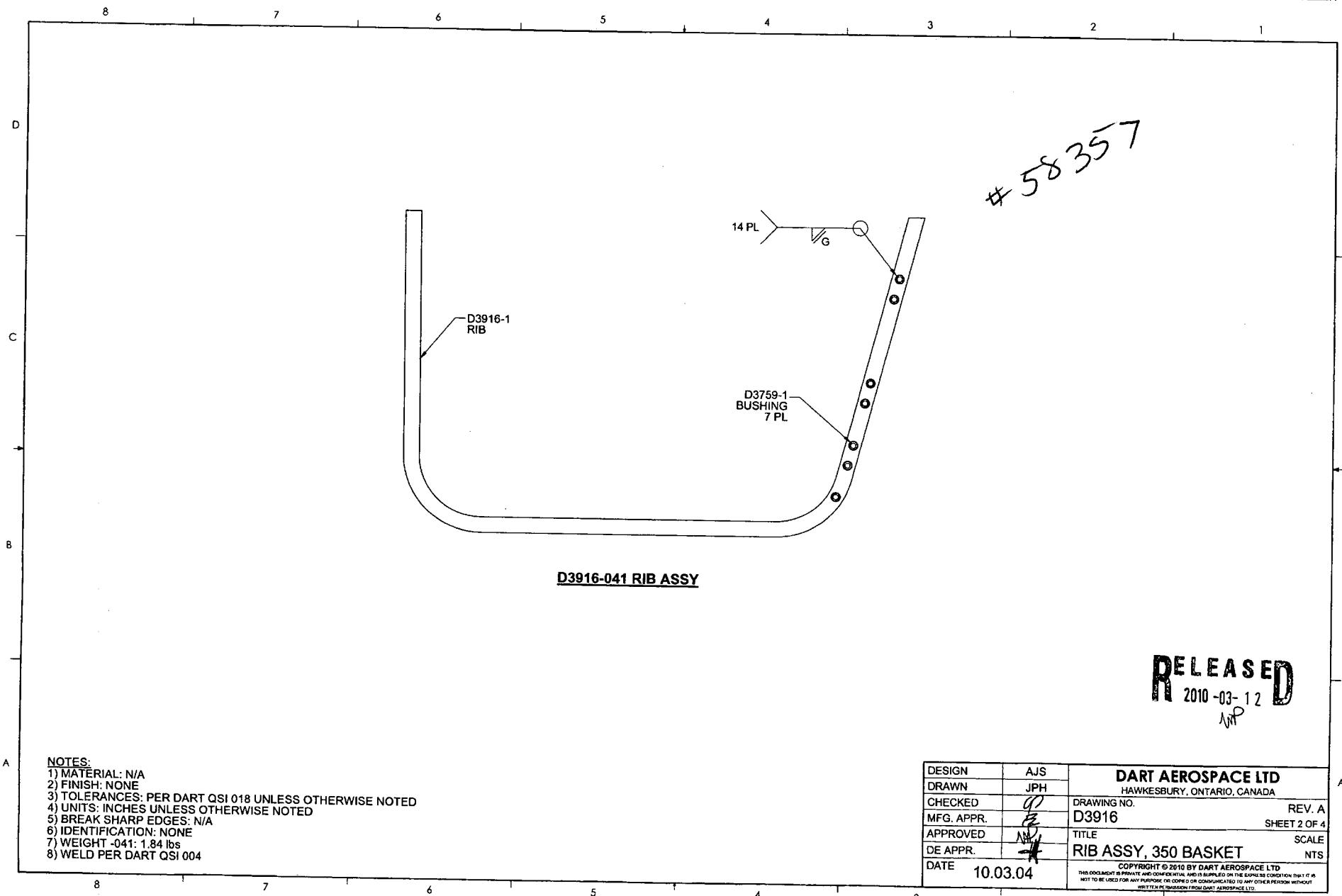
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	EE	D3916	SHEET 1 OF 4
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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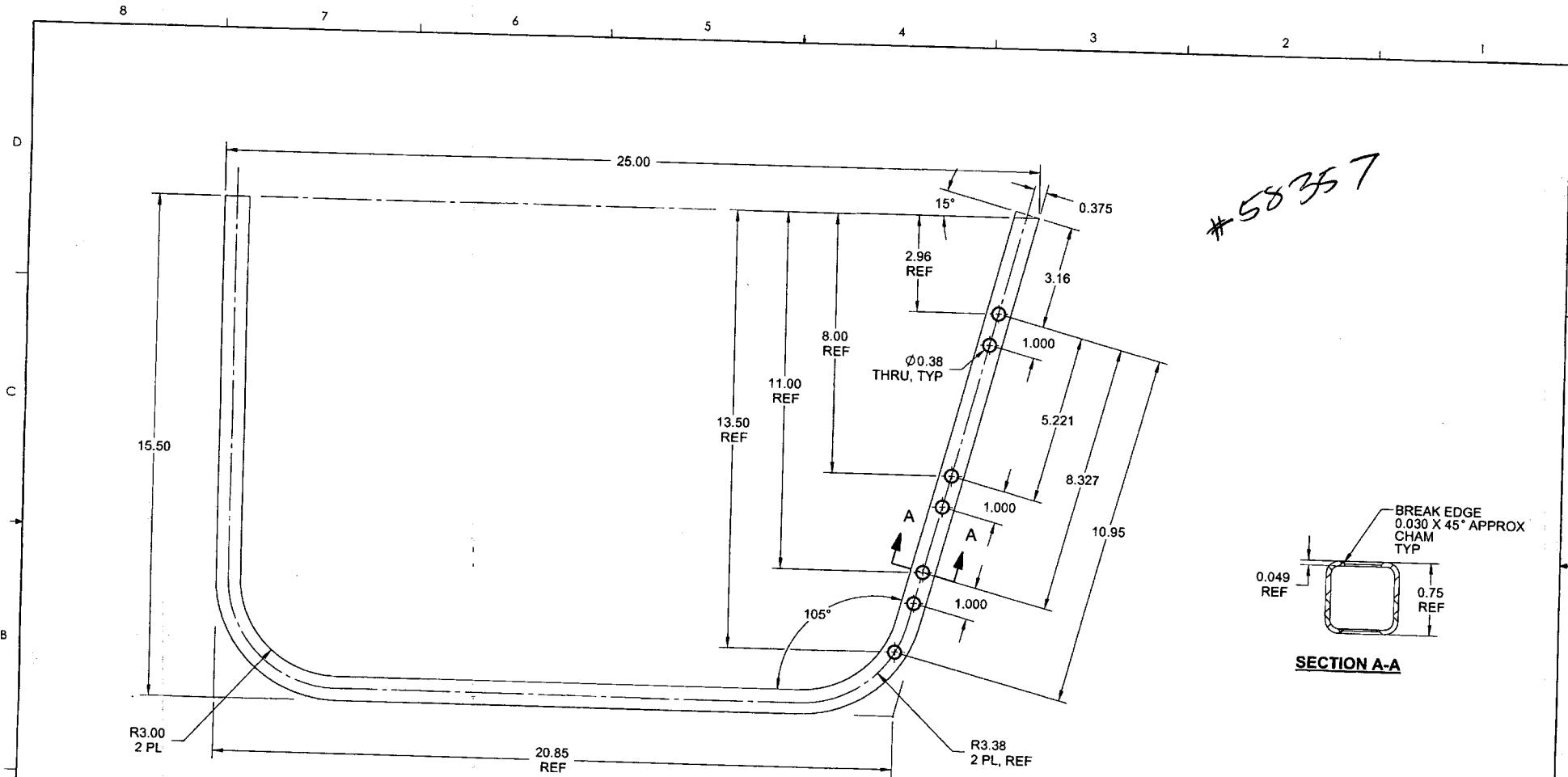
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[initials]	DRAWING NO.	REV. A
MFG. APPR.	[initials]	D3916	SHEET 2 OF 4
APPROVED	[initials]	TITLE	SCALE
DE APPR.	[initials]	RIB ASSY, 350 BASKET	NTS
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NOTE: Date & initial all entries



D3916-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

RELEASED
2010-03-12
[Signature]

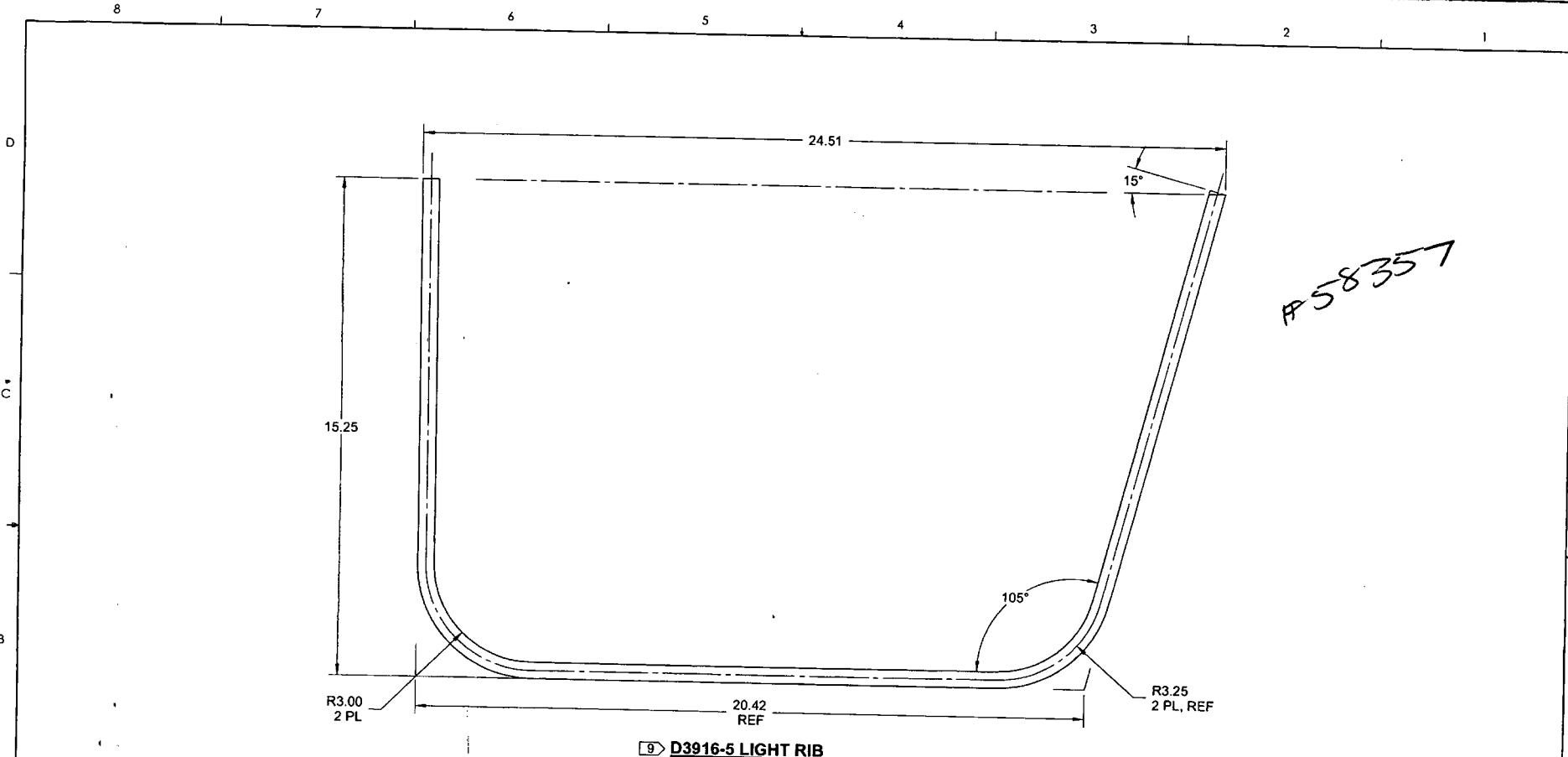
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>QO</i>	DRAWING NO.	
MFG. APPR.	<i>Z</i>	D3916	
APPROVED	<i>MM</i>	REV. A	
DE APPR.	<i>MM</i>	SHEET 4 OF 4	
DATE	10.03.04	TITLE	NTS
		RIB ASSY, 350 BASKET	

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2010-03-12
MM

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WORK ORDER CHANGES

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